

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019703**Date Inspected:** 27-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

NDT

BAY 10:

This QA Inspector performed randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as OBG Bike path Stringer plate. The weld designations reviewed are as follows.

BK010A4-001-001, 002, 003, 016, 017, 018

BK010A6-001-084, 085

BK010A7-001-028, 034, 036, 162, 170, 172, 088, 090, 094, 096

NDT Notification No-08297

This QA Inspector observed the following work in progress:

BAY 10:

Repair welding, SMAW Process:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed ZPMC qualified welding personnel identified as 500363, Perform Shielded Metal Arc Welding (SMAW) on OBG Bike path Stringer plate. Joint identified as BK010A6-084. ZPMC QC Identified as Deng Zhi Bing with temporary welding repair report. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) Repair. For more information see attached picture number 1.

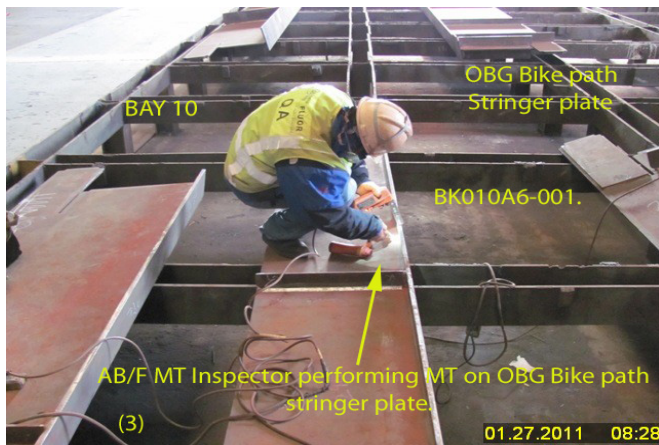
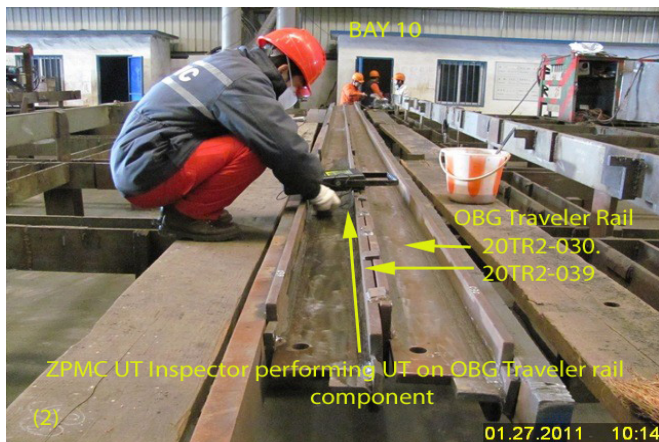
Ultrasonic Testing:

This QA Inspector observed ZPMC Ultrasonic Testing Inspector, performed UT on OBG Traveler rail joint. Joint identified as 20TR2-030-009, 011, 013, 015, 017 and 20TR2-039-009, 011, 013, 015, 017. For more information see below attached picture number 2.

Magnetic Particle Testing:

This QA Inspector observed AB/F Magnetic Particle Testing Inspector, performing MT on OBG Bike path Stringer plate. Joint identified as BK010A72-001-(031A, B). For more information see attached picture number 3.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho: 150002048250, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh
----------------------	------------------

Quality Assurance Inspector

Reviewed By:	Clifford,William
---------------------	------------------

QA Reviewer
